Work Orde July-06-12 3:10:		86842			*868	342*				•		Page 1
Item ID: Revision ID:		-			Accept	*N900	040	100)*	Setup Sta	1 7	S1* S2*
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D212-664-141		Rev D (DEO)								• .	
1 \\n^ \\ DC \\ Document Control	•	DOCUM	Memo Photocopy b		0.00 0.00 s as per PPP D212-664-101	16 7/4/-	30 ;		<u></u>	3.	<u> </u>	
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Packaging Packaging			Memo		0.00							
120					0.00	•			~ (, x

120 CNC Bend 2

BENDING MACHINE - CROSSTUBES

Memo

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio D212-664-101 CNC Alpha 160 Bender

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W/O:			WORK ORDER CHANGES										
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Work Or <i>July-06-12 3:</i>		6842		*868	342*						Page	
Item ID: Revision ID:	D212-664-	101		Accept	*N900	040	100) *	Setup	Start Stop	14.	S1*
Item Name:	Crosstube F	wd								осор	^N:	S2*
Start Date:	7/06/12	Start Qty: 1.00	*1*		Cust Item I	D:						
Required Dat	te: 8/10/12	Req'd Qty: 1.00	*1*		Customer:							
Reference:				•					_	G		
Approvals:	Process F	Plan:	Date:	Tooling:	Da	ate:			Run	Start		R1*
**	QC:		Date:	_ SPC (Y/N):	D:	ate:				Stop	*N	R2*
Sequence ID/ Work Center		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rejo Qty		Reject Number	Insp. Stamp
130		QC15- Crosstube Dimer	nsional Check	0.00								
130		Memo		0.00	1,2/24							

140

140 Crosstubes

Quality Control

Crosstubes

Crosstubes

Memo

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549,using drill table DT8577,set-up towers in hole #7 as per QSI 10

0.00

2-Ream hole to finish size in tube as per Dwg D212-664-141using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

4-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

Page 2

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W/O:			W	ORK ORDER CHANG	SES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Order ID 86842 July-06-12 3:10:33 PM		*86842*									Page 3		
Item ID: Revision ID: Item Name:	D212-664-1 Crosstube Fw			Accept	*N900	<u>)</u> 040	100)*	Setup	Start Stop	*N:	S1* S2*	_
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				SPC (Y/N):	D	Date:				Stop	*N	R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp	_
*150 *150* QC Quality Control		QC5- Inspect part comple Memo *** WEAR		0.00 PAS 0.00 P-89 N HANDLING CROSSTU	1/100/26								
160				0.00									S
160 HandFXtube Hand Finishing Cro	osstubes	Memo *** WEAR	LATEX GLOVES WHE	0.00 N HANDLING CROSSTU	BE***							W/ 12 5	16
		1- CLEAN (CROSSTUBE WITH WA	ASH'N WIPE									
170 *4 7 0*		Outsource process - ND7	per QSI038 4.1	0.00						10 1	2-07-	2-	
170 Outsource2		Memo		0.00							-0/-	27	
Outsource process	- NDT	*** WEAR	LATEX GLOVES WHE	N HANDLING CROSSTU	BE***								

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Work Order ID 86842 <i>July-06-12 3:10:33 PM</i>			*86842*							Page 4		
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Item Name:	Crosstube Fwo	d								Stop	*N:	S2*
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			Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
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180		Packaging		0.00						_/	2/2/	12/27
Packaging		Memo	. af NDT results attached t	0.00						C		
Packaging		Ensure copy	of NDT results attached t	to work order.								
190		QC5- Inspect part compl	leteness to step on W/O	0.00								1
190								,				N/12077
QC		Memo		0.00								
Quality Control		*** WEAR	LATEX GLOVES WHEN	N HANDLING CROSSTUBE	***			,				
		Inspect for o	damage & ensure results a	re as per Dwg D212-664-141								
193		Crosstubes Chemical Co	onversion	0.00				<i>A</i> 0				
103 HandFXtube		Memo		0.00				48	_ }	<u> </u>	7-2	8

1- PRESSURE WASH AND THEN USE WASH'N WIPE TO CLEAN CROSSTUBE BEFORE CHEMICAL CONVERSION

*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

Hand Finishing Crosstubes

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W/O:			W	ORK ORDER CHANG	iES					•
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Work Order ID 86842 <i>July-06-12 3:10:33 PM</i>		*86842*									Page 5		
Item ID: D212-664-101 Revision ID: Item Name: Crosstube Fwd Start Date: 7/06/12 Start Qty: 1.00 Required Date: 8/10/12 Req'd Qty: 1.00 Reference:		*1* *1*	Accept	*N900 Cust Item I Customer:		100)*	Setup	Start	1.7	S1* S2*		
Reference: Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	1/1	R1* R2*	
Sequence ID/ Work Center 195 *105* QC Quality Control	ID	Operation Description QC7-Inspect Chemical (Memo *** WEAR		Set Up/ Run Hours 0.00 0.00 EN HANDLING CROSSTU	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty	•	Reject Number	Insp.	 57 Z&
²⁰⁰ *200*		Spray Painting per QSI0 SprayPaint	005 4.2	0.00				Að) 2	2 - 7	- 28		

200

SprayPaint

Spray Painting

Memo

0.00

*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube as per DEO D212-667-141 with White Imron as per QSI 005 4.2

PRIME: \2\334 Start Time: <u>8!30</u> Fininsh Time: <u>9!15</u>

PAINT: 122381 Start Time: 4115 Finish Time: 5100

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Sequence ID/ Work Center II 210 *210* QC Quality Control	D	Operation Description QC14- Inspect Spray Pai Memo Then, Wrap	nt in plastic bag to protect fi	Set Up/ Run Hours 0.00 0.00 com scratches	Tool ID	Tool#	Plan Code	Accep Qty	t Reject Qty	Reject Numbe	Insp.
220 *720* Crosstubes Crosstubes		clean the are 2-Install sup	ating surfaces of support ha with 4105S wash 'n' wi ports with Proseal 890 po seal 890 Batch:	er DSI9563 and QSI 015	sandpaper,			A	<u>l</u> 12	<u>- 7-</u>	29

3- Torque bolts as per dwg

QC6- Inspect dimensions to drawing

Memo

230

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Quality Control

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arent Item Name:	Crosstube Fwd							Sta	rt Qty: 1	.00	J	Required	Qty: 1.00	
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Component Item ID/	strip ecn 11-549 Replacement	EC verified by:DD	Bin	Primary	Last	Route	Unit of Measure	Qty on	Qty per	· Kit To		Qty Issued		Status
tem Name	!tem ID	Purch	Item	Location	Location	Seq ID	Each	2.0000		Qt	y 1	155463		
212-664-101TRN Prosstube Turning Detail	1	Manufactured	No			110	Each	2.0000	date:	SA	0	12.0	7-23	
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July-06-12 3:10:33 PM

Work Order ID:	86842												
Parent Item:	D212-664-101						Start I	Date: 7/06/12	F	Required :	Date: 8/1	0/12	
Parent Item Name:	Crosstube Fwd						Start	Qty: 1.00		Required	Qty: 1.0	00	
MS21920-25 Clamp(per MIL-DTL-878	33C)	Purchased	No		220	Each	136.0000	4	4	Al	2-7	-29	
				Location	Loc Oty		Loc Code						
	•			LG050	117								
				116264	2								
				117998	4								
				118142	4								
				119339	2								
				119746	2								
				120475	7								
				120920	46								
				122204	50			<u>(4)</u>					
				LG051	19								
				121583	19								
D2893-1		Manufactured	No		220	Each	16.0000	2	2	10	12-7	. 9a	
2.75 Support				87922							(d = /	7×7	
				Location	Loc Qty		Loc Code	@					
				LG	9								
				83056	9		4						
				LG052	7		•						
				72865	2								
				80271	. 4			-					
				82228	1								7
D3428-1		Manufactured	No		240	Each	33.0000	1 17/2	12/35/	2		6	
Placard									· · · · ·				
				Location	Loc Qty		Loc Code						
				ST042	33								
				78933	2			<i>(</i>					
				81881	9								
				83582	10								
				85228	12								



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W/O:		***************************************	WO	RK ORDER CHAN	IGES			,		. •
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	1	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				<u>, , , , , , , , , , , , , , , , , , , </u>			·			
Part No	:	PAR #:	Fault Categ	jory:	NCR: Y	es N	o DQ	A:	Date:	
	Re	esolution:	Disposition: QA						Date: _	
NCR:			WORK ORDE	R NON-CONFOR	MANCE (N	CR)				
DATE	STEP	Description of NC		ection B			ation		Approval	
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		on C	Chief Eng	QC Inspector
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Picklist Print
July-06-12 3:10:33 PM

Work Order ID: Parent Item: Parent Item Name:	86842 D212-664-101 Crosstube Fwd							Date: 7/06/12 Qty: 1.00	Required Date: 8/10/12 Required Qty: 1.00
AN6-35A BOLT		Purchased	No		240	Each	42.0000	4	4
3				Location	Loc Qty		Loc Code		
				342	42			*	·
				121181	42				
_ AN6-36A Bolt		Purchased	No		240	Each	47.0000	4	4 2 6
				Location	Loc Qty		Loc Code		
				ST342	47				<u></u>
				118422	2				
				119449	i			-	
				120187	4				
				120423	40				$ \cap$ \mathscr{M}
MS21042L6 Nut		Purchased	No	<u> </u>	240	Each	497.0000	6	5 h 6
				Location	Loc Qty		Loc Code		1
				ST300	497				
				117677	25				
				118384	3				
				118927	48				
				119075	221			K	2
				120308	200				
AN960JD616 Washer	NAS1149D0663J	Purchased	No		240	Each	0.0000	18	18 M12170;
									12/2/

									•				
W/O:			WORK ORDER CHANGES										
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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						,							
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	Date: _							
	Re	solution:	Disposition	: <u>`</u>	QA: N/C CI	osed:		Date: _	 				
NCR:			WORK ORDE	NCE (NCR	1)								
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	n B Sign &		Verification App		Approval				
		Section A	Chief Eng	Chief Eng	Date	Sect	ion C	Chief Eng	QC inspector				
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DART AEROSPACE LTD	Work Order:	84842
Description: Crosstube High Fwd (205/212/412)	Part Number:	D212-664-101
Inspection Dwg: D212-664-141 Rev: D		Page 1 of 1

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7
Bending Passes	3	
Crushing		6%

706 + 4.826		209 - 4.841 4.37	
2.516	7	2.525	
263			76.800 1
A 53.632 ¹	9 8	53.750 ^u B	<u>;</u>
	— 107.560° —		

	Side A	Side B
Bending Passes	9 =	8
Crushing	4.2%	4.3%
	Comments	
SiDE A = 9	Pases.	
miDDle 2 7	082500.	
5 No R 2 90	00-5500	

QC15 Inspection	DAG .
Date	17/03/24

Rev	Date	Change	Approved	
Α	07.02.06	New Issue	KJ/JM	
В	08.04.21	Dwg Rev updated	KJ/JM	
С	10.04.01	Dwg Rev updated	KJ . N	
D	12.04.16	Added bending, crushing dimensions	KJ 🖎	W

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W/O:			W	ORK ORDER CHANG	ES	-		· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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•									
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	n: <u>'</u>	_ QA: N/C Cld	sed:		Date: _		
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)	•		
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DATE	SIEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
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ltem	Qty -141	Qty -141B	Part Number	Description
1	X		D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		Х	D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

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1) MATERIAL: MANUFACTURED FROM D6005-128 FINISHED LENGTH = 126.514±0.020

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART QSI 005 4.2

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS
- WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664) D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY RETURN'TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

REMOVED FROM WIDER REVIEW PER UNDER REVIEW SCA #11-64

DEO ATTACHED

REFORMAT/REVISE GENERAL NOTES/PART LIST; 09.09.30 REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO REMOVE -851 ABRASION STRIP: ADD MAGNOBOND С 07.03.08 6398, CUSHION, REVERSE CLAMPS ADD HOLES FOR COMPATABILITY WITH BHT/AA В 05 02 04 SKIDTUBES NEW ISSUE Α PH 00.12.12 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. D

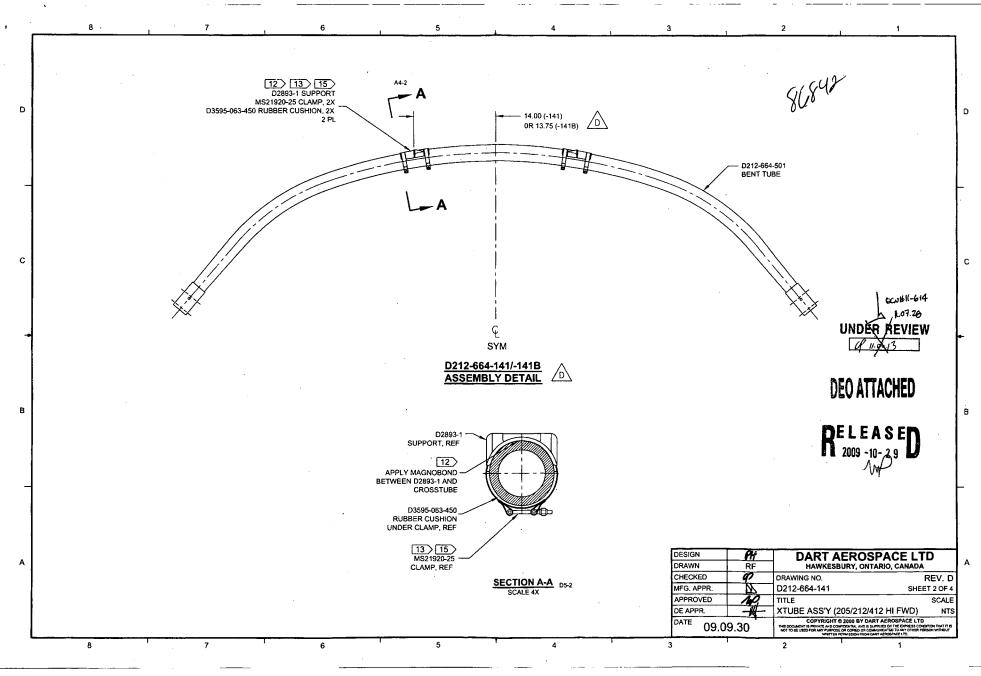
CHECKED MFG. APPR. D212-664-141 SHEET 1 OF 4 APPROVED TITLE SCALE DE APPR. XTUBE ASS'Y (205/212/412 HI FWD) NTS COPYRIGHT © 2000 BY DART AEROSPACE LTD IT IS PRIVATE AND COMPRESS OF COMMITTEED FOR ANY PURPOSE OR CODIED OR COMMUNICATED TO ANY OTHER PERIOD PROPERTY OF THE PE DATE

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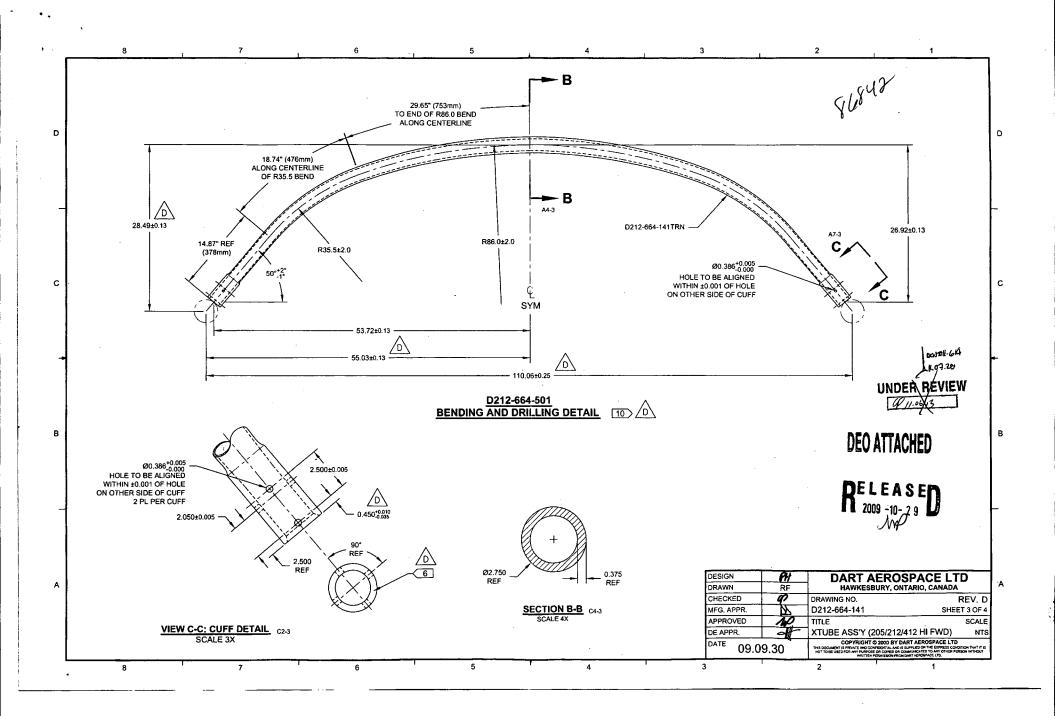
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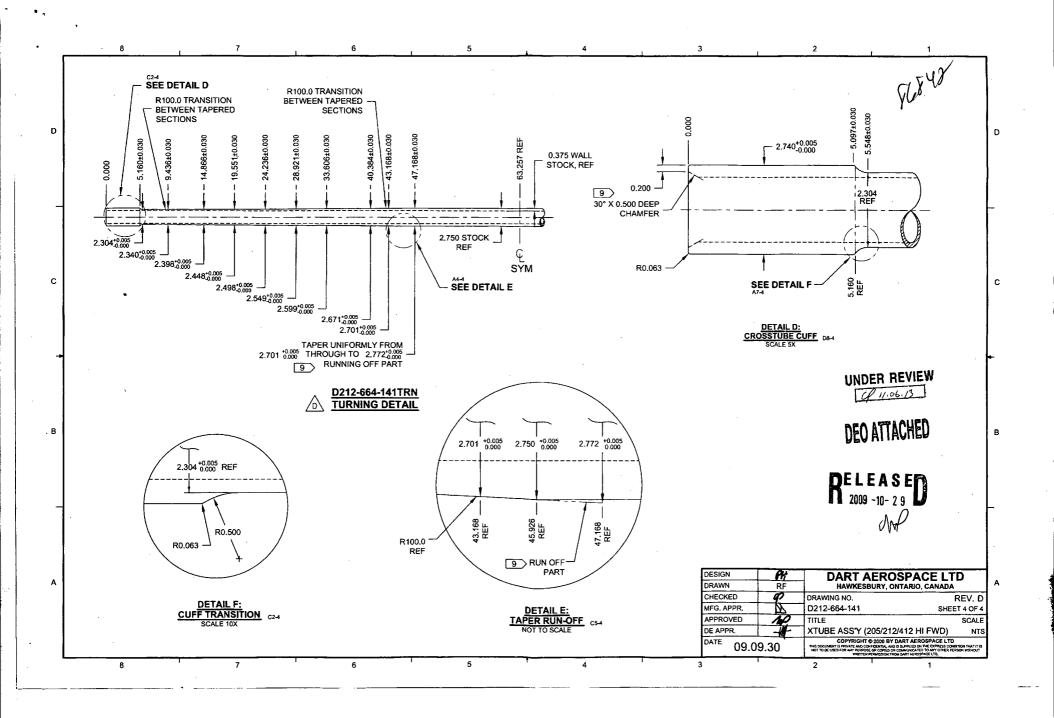
W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	•	QA: N/C C	closed:		Date: _		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	Initial		V			Approval	
		Section A	Chief Eng	Action Description Chief Eng	Date		on C	Chief Eng	QC Inspector
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Part No		PAR #:	Fault Cate	jory:	NCR: Yes	No DQA	\ :	Date: _	
	Resolution: Disposition:					osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	3)			
DATE	STEP	Description of NC	Description of NC Section A Initial Chief Eng Corrective Action Action Des		Section B Verif				Approval
	O.L.	Section A			Sign & Date	Section C		Chief Eng	QC Inspector
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	Re	esolution:	Dispositio	n: <u>·</u>	QA: N/C C	closed:		Date:	
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section B			cation		Approval
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		solution:							
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC			ction B		cation	Approval	Approval
DAIL	July	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
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DRAWING	NO.	TITLE	·	REV. D	DART AE	ROSPACE LTD	D.E.O. NO	•	SHEET NO.	SCALE
D212-66	4-141	XTUBE ASS	Y (205/212/412 HI	FWD)	ENGINE	ERING ORDER	D212-66	4-141-D-1	SHEET 1 OF	2 NTS
DRAWN			CHECKED	P	MFG. APPR.	Œ	APPROVED	MP,	DE APPR.	_
DATE	11.04	.07	DATE)	1, 04, 11	DATE	11.04.12	DATE	11/04/12	DATE 11.0	4.12

PURPOSE:

ADD AN INSPECTION WINDOW TO UNDERSIDE OF CROSSTUBE.

CHANGE:

NOTES 2 OF SHEET 1 IS AMENDED AS FOLLOWS:

IS:

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2

MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND

PAINT OUTSIDE PER DART QSI 005 4.2 REMOVE MASKING AND APPLY CLEAR COAT

WAS:

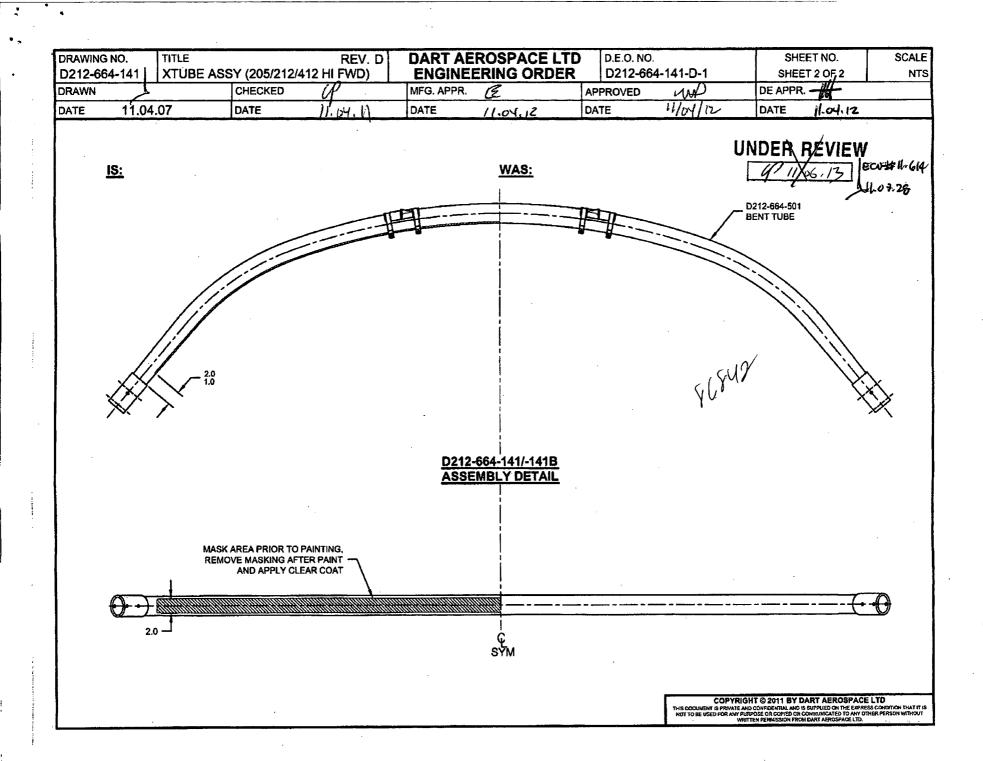
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2

PAINT OUTSIDE PER DART QSI 005 4.2



W/O:	•		1410	DK ODDED CHANCE				·	
				ORK ORDER CHANGE	I			Approval	Approval
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Chief Eng / Prod Mgr	QC Inspector
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Part No:		PAR #:	Fault Cate	NCR: Yes	Vo DQ	4 :	Date:		
Resolution:			Disposition	n: '	QA: N/C Clo	sed:		Date: _	
NCR:		1	WORK ORDI	ER NON-CONFORMAN	ICE (NCR)			
DATE	0750	Description of NC Section A	Corrective Action Section B			Verific	ation	Approval	Approval
DATE	SIEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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Dart Aerospace L	.td
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		,								
					-					
Part No		PAR #: Fault Category:	NCR: Yes		<u>.i</u>	Date:	1			

•	Resolution:		Dispositio	on: '	QA: N/C Clos	sed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMAL	NCE (NCR)			
	T	Description of NC		Corrective Action Section B				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC inspector
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		* , ** , ***,						

DRAWING NO.	TITLE	REV. D	DART AEROSPACE LTD	D.E.O. NO.	SHEET NO.	SCALE
D212-664-14	11 CROSSTU	BE ASSY (205 HI FWD)	ENGINEERING ORDER	D212-664-141-D-2	SHEET 1 OF 1	NTS
DRAWN	W	CHECKED A>>	MFG. APPR	APPROVED MA	DE APPR.	
DATE 1	1.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21	DATE 11.07.2	(

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

item	Qty -141	Qty -141B	Part Number	Description
7	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023
1				ADHESIVE (TEXTRON/BELL SPEC. 299-947-100,
				TYPE II, CLASS 2 ADHESIVE)

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2893-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

WAS:

- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr S QC Inspector					
*				;							

Part No:	PAR #:	Fault Category:		NCR: Yes No	DQA:	Date:
Resolution:		Disposition:	•	QA: N/C Closed	i: _¹	Date:

NCR:	•	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B.		Verification	Approval	Approval		
DATE	STEP	- Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC inspecto		
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					PAGE OF
CLIENT	DAT AGO SACE		DATE 🛣	-1407/12	TIME AM PM 3
ATTENTION -	MAT/LINDA		ACUREN JOB NO.	188-12-	CO 293
ADDRES:	1270 ABENDEEN	57.	PO/WO No.	17556 -	
	HAWKET BUT ON.		Work Location	SALE	
			ACCEPTANCE STD	67M 1417/051-038	REV./DATE Dec 5
['ROJECT	F.P.I. O	N CRO-	SS TUSE	8	
ITEM(S) EXAMINED		10 P	65		
-					
JOB DESCRIPTION	PROCEDURE No. LT	REV./DATE	2008 TE	ECHNIQUE NO. LT 1542	Rev./Date 2608
Part No.	SEE RESULT	r <u> </u>	MATERIAL ALL		KNESS VARCOUS
SCOPE A C	ET FLOURESCENT	LIOU	O PENET	RANT EXAMI	NATION WAS
Duck	r -1.5 Or	of Sent	ACE ONL	<u> </u>	
TEST DETAILS					
METHOD		J VISIBLE	WATER WASH	SOLVENT REMOV	
FAMILY BRAND	MAGNAFICER ZLG7 MINIMUM DWELL TIM	= 45 18 Min.	BLACK LIGHT S/N /	CYSS OUTPUT > 1000	µ W/cm ² ☐ AMBIENT < 2 fc ☐ OUTPUT>100 fc @ SURFACE
PENETRANT PENETRANT REMOVER		>10 Min.		BINO	
DEVELOPER S	P 52 MINIMUM DWELL TIM		LIGHT METER S/N	1098866	CAL DUE DATE COLOR
CEVELOPER TYPE	Non Aqueous	☐ DRY			2012.
TEST SURFACE UNREACE CONDITION	☐ As GROUND ☐ As \	V ELDED	☐ MACHINED	☐ SHOT BLASTED	☐ CLEAN BARE METAL
SURFACE TEMPERATU		C/ 20°F TO 10°C/50°I		□ 10°C/50°F TO 52°C/125°F	□ > 52°C/125°F
RESULTS-	(METRIC IMPERIAL)		I ser ser		
	C - P -	81.05 J. 1. 12.11		Continue of the Continue of th	
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1111111	* 83094		M	12 07 20	•
Control of	up Inc. to perform services extends only to those services	amounted for in maining 11 3	r no circumstance shall such		the requested services. It is expressly unacritical
Lead of Alabana and a common of	up Inc. to perform services extends only to those services is and expressions of opinion reflect the opinions or obser Acuren Group Inc. is not assuming any responsibilities	vations of Acuren Group Inc. I	based on information and ass	umptions supplied by the owner/operator an	a are not intended not can they be considered.
data or other information prov	vided by Acûren Group Inc. In no event shall Acuren Gro	up Inc.'s liability in respect of	the services referred to hereir	n exceed the amount paid for such services.	
In performing the services pro implied, is made or intended b	ovided, Acuren Group Inc. uses the degree, care and skill or ov Acuren Group Inc.	ordinarily exercised under sim	ilar circumstances by others p	performing such services in the same or sim	lar locality. No other warranty, expressed or
SIGNATURES	- Comp no				
CLIENT REPRESENT	ATIVE NAH MORDOCK	m/l.	Allen Pollan	dal DTR#	E-117397
_	PRINT		SIGNATURE	REPORT	
TECHNICIAN (SIGNATU	JRE):	<i></i>		REVIEWED BY:	
NAME (PRINT): 2	14. KE JOHN PL		2 ^{NO} TECHNICIAN		NAME INITIALS
	CGSB LEVEL SNT LEVE		VEL SNT LE	EVEL	
	CGSB REG. NO 6606	CGSB Re	G. No		

86842

Mr-06-12 3:10:33 PM

Item 1D:

D212-664-101

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crosstube Fwd

Required Date: 8/10/12

Start Date:

7/06/12

Start Qty: 1.00 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

R

Date: 277-9 Tooling:

:

Date:

Tool # Plan

Code

Run Start

NR1

NR2

12 (07 130

.

Sequence ID/

Work Center ID

QC: _____Operation

Description

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Accept Qty

Reject Reject Oty Number

Stop

Reject Insp. Number Stamp

Draw Nbr

Revision Nbr

D212-664-141

Rev D (DEO)

*100 *100*

DOCUMENT CONTROL

DC

Memo

0.00

0.00

Document Control

Photocopy bluefile and create labels as per PPP D212-664-101 CHG005

110

110

Packaging

Pick Kit

Packaging

Memo

0.00

0.00

Packaging

120

120 CNC Bend 2 BENDING MACHINE - CROSSTUBES

Memo

0.00

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and

Folio D212-664-101

January (vacanama)